

## CLAIMS:

1. A spoke for a tensioned spoke wheel, said spoke comprising  
a shaft having first and second ends, a first segment of said shaft adjacent the first  
5 end having a given cross-sectional area, and a second segment of said shaft adjacent, and  
toward the second end from, said first shaft segment having a cross-sectional area less  
than the given area, said first segment having a threaded portion and an unthreaded  
portion which is adjacent to said threaded portion and is between said threaded portion  
and said second end,  
10 wherein the surface of a part of said unthreaded portion of said first segment is  
shaped to form at least two opposed, flat, torque transmitting surfaces.
2. A method for producing a spoke comprising a shaft having first and second ends, said  
first end including a threaded portion and an unthreaded portion adjacent to said threaded  
15 portion, wherein said unthreaded portion includes at least two torque transmitting surfaces  
consisting of opposed flat surfaces, said method comprising the steps of  
engaging the unthreaded portion of the spoke between two spaced, generally  
parallel tool surfaces,  
advancing the spaced surfaces, one towards the other, until they engage the  
20 unthreaded portion of the spoke, and beyond, so that the surfaces permanently and  
inelastically deform the unthreaded portion to produce the two torque transmitting  
surfaces, and  
releasing the spoke from the tool surfaces.
- 25 3. A spoke for a tensioned spoke wheel as claimed in claim 1 wherein, when the spoke is  
installed in a wheel under tension applied by a nipple or nut into which the spoke is  
threaded, the cross sectional area thereof is sufficiently small that said second segment is  
subject to rotation therewith when the nipple or nut is rotated to increase the spoke  
tension.
- 30 4. A spoke for a tensioned spoke wheel as claimed in claim 1 which, except for said flat,  
torque transmitting surfaces, is generally circular in cross section.

5. A spoke for a tensioned spoke wheel as claimed in claim 1 which additionally has a third segment which is between said second segment and the second end of the spoke, wherein said third segment has a cross-sectional area greater than that of said second segment.

5

6. A spoke for a tensioned spoke wheel as claimed in claim 5 which, except for said flat, torque transmitting surfaces, is generally circular in cross section.

7. A spoke for a tensioned spoke wheel as claimed in claim 4 wherein the major diameter of the threaded portion of said first segment is greater than the diameter of said first

10 segment of the spoke.

8. A spoke for a tensioned spoke wheel as claimed in claim 6 wherein the major diameter of the threaded portion of said first segment is greater than the diameter of said first segment of the spoke.

15

9. A spoke for a tensioned spoke wheel, said spoke comprising

a shaft having first and second ends, a first segment of said shaft adjacent the first end having a threaded portion and an unthreaded portion which is adjacent to said threaded portion and is between said threaded portion and said second end, and a second

20 segment of said shaft adjacent, and toward the second end from, said first shaft segment,

wherein the surface of a part of said unthreaded portion of said first segment is shaped to form at least two opposed, flat, torque transmitting surfaces, said spoke, when installed in a tensioned spoke wheel with a nipple threaded onto the threaded portion of the first segment of said spoke, being subject to rotation therewith when the nipple is

25 rotated, and the unthreaded portion of the first segment of the shaft has a sufficiently large cross-section, the shaped portion of the surface of the first segment is sufficiently close to the threaded portion thereof, or both, that preventing rotation of the shaped portion of the first segment surface prevents rotation of the spoke with the nipple.